

(B)

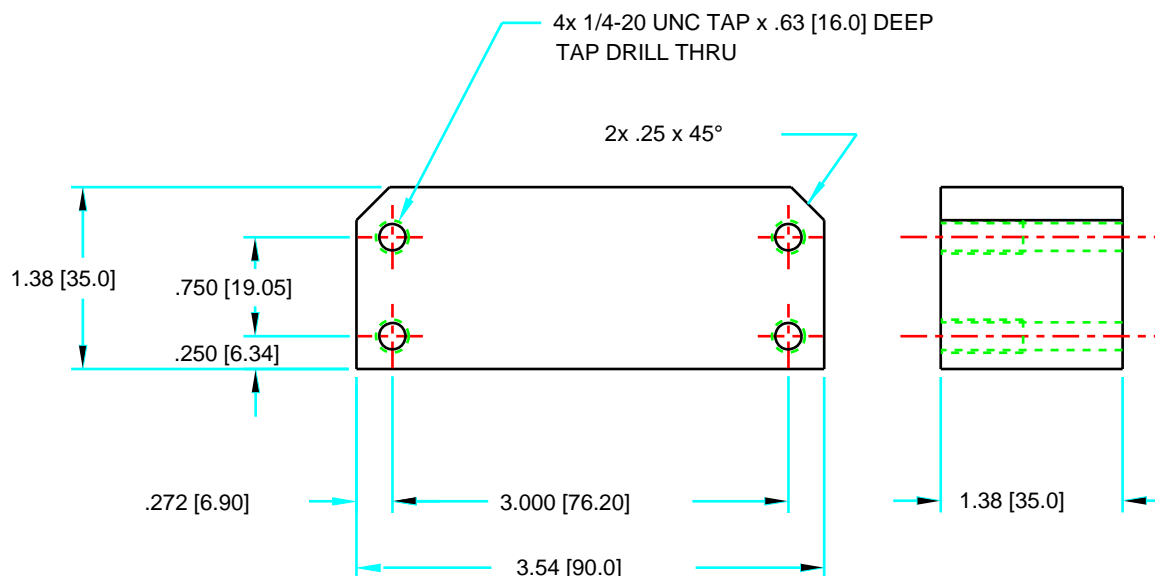
PLOT SCALE: 1=1

DWG. SCALE: 1

A2073000

NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON
5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. BREAK ALL SHARP CORNERS 0.01 MINIMUM
9. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
10. SURFACE ROUGHNESS ✓ 63



APPROX. WT. = 4.5 LB.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS .X - .03 .XX - .01 .XXX - .005 ANGULAR - .25 SURFACE ROUGHNESS ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		LOG NUMBER A2073000 THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY UNIVERSITY OF CHICAGO		
DRAWN BY J.GOGOL	DATE 8/2/94	CHIEF DESIGN ENGINEER D.SHU	DATE 10/19/94	TITLE ADVANCED PHOTON SOURCE
CHECKED BY J.CHANG	DATE 10/17/94	GP LEADER T.M.KUZAY	DATE 10/19/94	P9-30 INTEGRAL SHUTTER (D) TUNGSTEN BLOCK
DESIGNER J.GOGOL	DATE 8/2/94	PROJECT MGR.		
RESPONSIBLE ENGINEER J.CHANG	DATE 10/17/94	APPROVED/RELEASED		
MATERIAL SEE NOTE #4		SCALE 1:1	SIZE B	DRAWING NUMBER P4105090909-320001-00
DO NOT SCALE DRAWING		SHEET 1 of 1		

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				